

Work Order ID 122217

July-10-14 1:18:49 PM

\*122217\*

Page 1

Item ID: D4973-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Upper Cutter Deflector 5  
 Start Date: 7/10/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/10/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: MJS Date: 14-07-10 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4973	C

100 \*100\* FLOW WATER JET 0.00 0.00 6 0 DAS 23 9-89 14-07-21

Waterjet  
 FLOW CNC Waterjet  
 Memo  
 1-Cut as per Dwg  
 Dwg Rev: C  
 Prog Rev: C  
 2-Deburr if necessary

110 \*110\* QC 0.00 0.00 6 0 DAS 23 9-89 14-07-21

Quality Control  
 Memo

114 \*114\* Mill Conv 0.00 0.00 5 1 DAS 23 9-89 14-07-21

Conventional Milling Machine  
 Memo  
 DRILL HOLES AS PER DWG  
 MILL STEP AND BOTTOM FACE

SCRAP



Work Order ID 122217

\*122217\*

Page 2

July-10-14 1:18:49 PM

Item ID: D4973-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Upper Cutter Deflector  
 Start Date: 7/10/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 7/10/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
116	QC2- Inspect parts off machine FAI/FAIB	0.00				5	1		
*116*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

QC-L 14/07/28

**Work Order ID 122217**

July-10-14 1:18:49 PM

**\*122217\***

Page 3

Item ID: D4973-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Upper Cutter Deflector

Start Date: 7/10/14 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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121

0.00

**\*121\***

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O: \_\_\_\_\_

TO:ATG

ANODIZE AS PER DWG

PRIME AS PER DWG

C OF C IS REQUIRED

132

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*132\***

Packaging

Memo

0.00

Packaging

# Picklist Print

July-10-14 1:18:53 PM

Page 1

Work Order ID: 122217

**\*122217\***

Parent Item: D4973-1

**\*D4973-1\***

Parent Item Name: Upper Cutter Deflector

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 13-11-19 JLM VERIFIED BY:DD  
REV:B 14.06.16 AS PER DWG REV.C DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M7075T6B0.375X8.000

Purchased

No

f

13.8493

**\*M7075T6B0 375X8 000\***

**\*\***

DAS  
23  
9-89

14-07-21

7075-T6 BAR 0.375" X 8.000"

Location

Loc Qty

Loc Code

MAT001

13.8493

123611

2

125428

2

m126390

1.6242

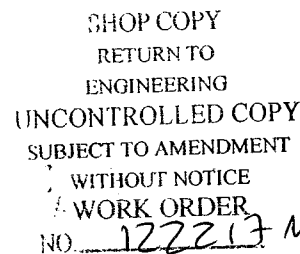
m128502

8.2251

128502







RELEASED  
2014-06-11

NOTES:

- |            |  |  |              |
|------------|--|--|--------------|
| C          | REMOVED HOLES AND REVISED HOLE LOCATION<br>(ZN C6-1). REMOVED DETAIL B, REVISE NOTE 6) (ZN A8-1) | AK   | 14.05.26     |
| B          | ADDED HOLES TO D4973-1   | AK   | 14.05.06     |
| A          | NEW ISSUE  | DC   | 13.11.11     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | DC   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | RF   |  |              |
| CHECKED    | HS   | DRAWING NO.  | REV. C       |
| MFG. APPR. | JLM  | <b>D4973</b>   | SHEET 1 OF 1 |
| APPROVED   | HS   | TITLE  | SCALE        |
| DE APPR.   | DS   | <b>UPPER CUTTER DEFLECTOR</b>  | NT           |
| DATE       | 14.05.26   | COPYRIGHT © 2013 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. |              |





DQA:

Date: 14/07/24



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 9/11

Date: 14/7/30

Work Order update only ☐

Work Order: 122 217	<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. 04973-1	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. 14-4087	Scrap <input checked="" type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.07.24	114	1	R1.0 in Rad (C5-1) was 20.5 in	A.P. 14.07.24	SCRAP PART no Replm.	J.C.L. 14/07/24	D.A. 14/07/28	DAS 16 9-89 14/07/23
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier	14/07/28	# 116	5	0.340 ±0.000 area is centered -0.003 instead of being to one side	DAS 16 9-89 Q22042 14/07/28	SCRAP destroy And Replae	J.C.L. 14/07/28	D.A. 14/07/28	DAS 16 9-89 Q22042 14/07/28
Training									
Transport									
Unapproved									

check / operator Eng. FAULT CATEGORY

<b>Landing Gear</b>		<b>General</b>		<b>FAULT CATEGORY</b>	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input checked="" type="checkbox"/> Set-up	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			

23

1 141

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by: J.C. - L.	Audited by:	Preliminary Approval:
Date: 14/07/28	Date:	Date:

H:\FORMS\Quality Assurance\approved QA\FAI revE

